

Work Order ID 163388

163388

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Tuesday, June 27, 2017 11:36:08 AM

Item ID: D4682-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 7/11/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4682	D

100 0.00
100
Waterjet 1.36
FLOW CNC Waterjet
Memo
1-Cut as per dwg
prog rev: B
dwg rev: B
2-Deburr if required
④ SC 17/07/05
DAS
45
9-89

110 0.00
110
QC 0.04
Quality Control
Memo
QC2- Inspect parts off machine FAI/FAIB
④ SC 17/07/05
DAS
45
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144		0.00				4			DAS 41 9-89
144									
HandFinish	Memo	0.00							JUL 21 2017
Hand Finishing	1- Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: <u>137803</u>								
	2- Indicate FWD direction as shown using white paint marker(SEE NOTE 11)								
146	QC5- Inspect part completeness to step on W/O	0.00				4			DAS 38 9-89
146									
QC	Memo	0.08							JUL 24 2017
Quality Control									
150	Identify as per dwg & Stock Location: <u>5H604</u>	0.00				4			JUL 26 2017
150									
Packaging	Memo	0.04							
Packaging	LOCATION: WA001								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							
Quality Control									

**DAS
21
9-89**

JUL 26 2017

Picklist Print

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Parent Item: D4682-7

D4682-7

Parent Item Name: Wearplate

Start Date: 7/11/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA		Purchased	No			100	sf	109.6099	3.12	13.13684			
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M304S18GA

304/316 .050 Sheet

**

SEAS 17/07/09

45
9-89

Location

Loc Qty

Loc Code

MAT020

108.8059

M135779

7.12

M136036

4.65

M136568

16.8959

M136687

2.24

M136790

13.9

M137481

64

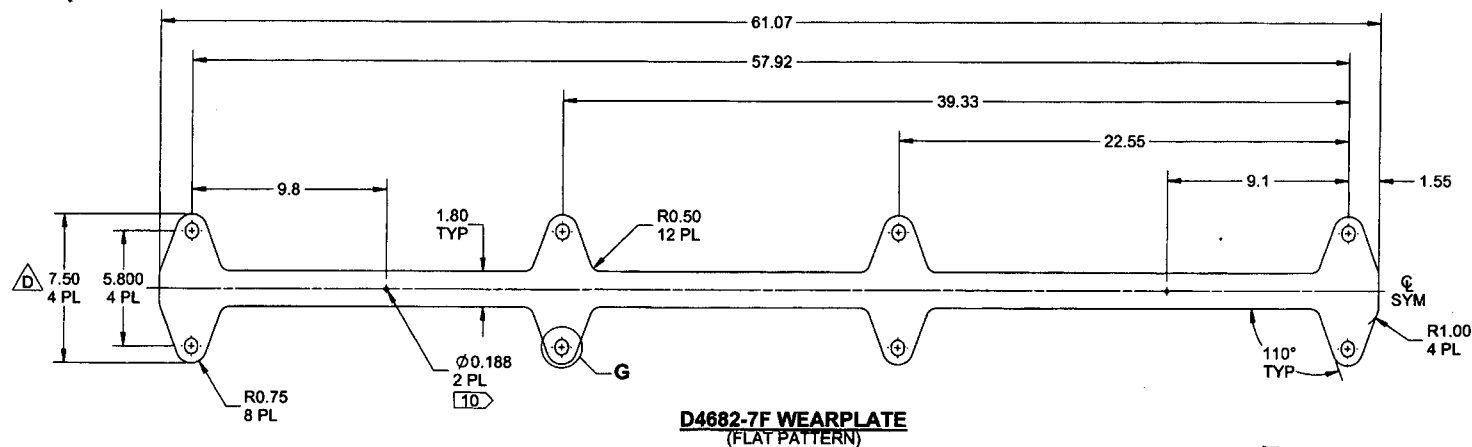
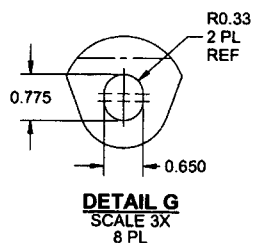
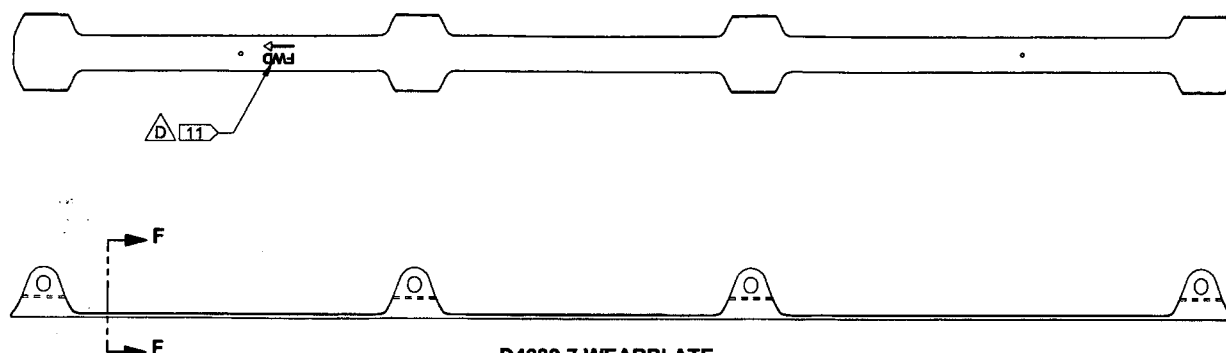
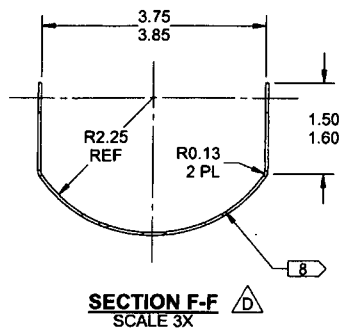
MAT20

0.804

M134580

0.804

14



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.28 lbs
- 8) FORM USING R1.9 DIE
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK AFTER BENDING PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163388 MJS
170703

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 7 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.03.24	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.	
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